

Date: Friday, 24/10/2008 3:32:10 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE
Job Number : 42960	
Estimate Number : 13372	
P.O. Number :	
This Issue : 24/10/2008 S.O. No. :	Part Number : D37691
Prsht Rev. : NC	Drawing Number : D3769 REVA
First Issue : / / Type : SMALL /MED FAB	Project Number : N/A
Previous Run : 40975	Drawing Revision : A
	Material :
Written By :	Due Date : 03/11/2008 Qty: 12 Um: Each
Checked & Approved By : <u>Julie Dawson 10-24</u>	
Comment : Est Rev:A 08-06-18 rev.A as per dwg DD verified by:EC Est Rev:B 08-08-27 Drilling Tooling Added JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T1000W065	6061T6 RD TUBE 1.00 x .065w
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Comment: Qty.: 1.2642 f(s)/Unit Total : 15.1704 f(s)

6061T6 TUBE (1.00" x 0.65" wall)

batch: _____

M109760

09/01/06

(12)

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-cut tube to length as per dwg D3769

2-drill holes thru on both ends of tube as per dwg D3769 using DT9411 Jig

3- deburr

M-d 09/01/06

(12)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/01/06 (12)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AWM 9-01-06

(12)

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	-----------------------------------------



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 09/01/07 (12)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 24/10/2008 3:32:10 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 42960

Part Number: D37691

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST251

JS 09/01/07 @

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

JS 09/01/07

Job Completion



h 09.01.07

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

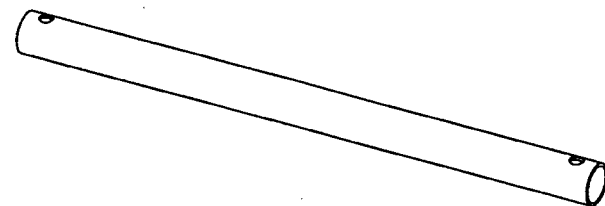
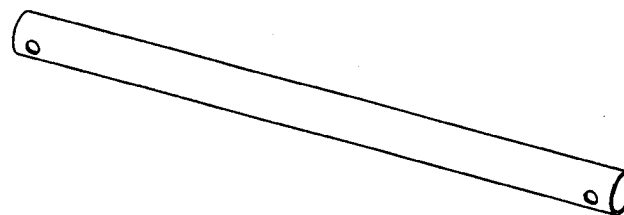
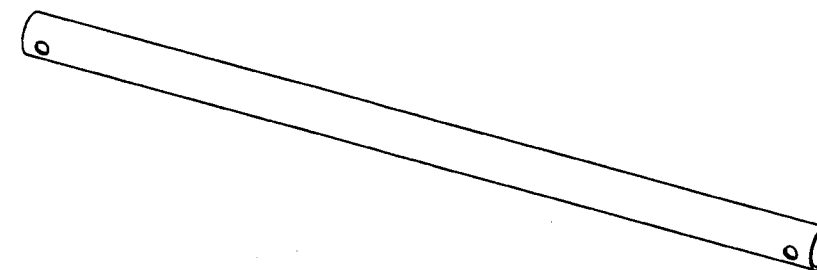
5

4

3

2

1

**D3769-1 TUBE****D3769-3 TUBE****D3769-5 TUBE**

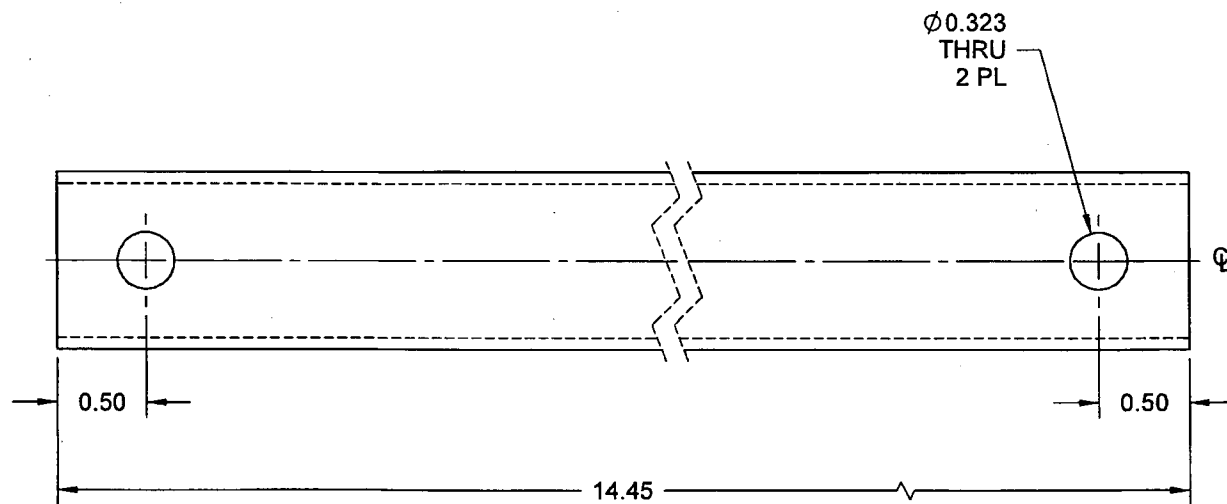
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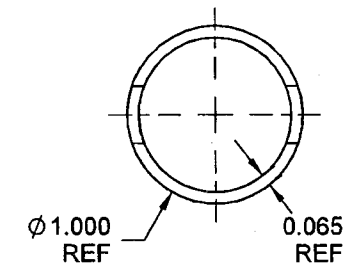
NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER VVW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3769-1, 0.27 lbs
D3769-3, 0.28 lbs
D3769-5, 0.37 lbs

A	NEW ISSUE		HS	08.06.04
REV.	DESCRIPTION		BY	DATE
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D3769-1 TUBE



499
1616
4384

2 1616
2 323
12 12/32

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